

Work Order ID 75199

75199

Page 1

October-18-11 3:30:05 PM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: *Alike* Stop ***NS2***
 Item Name: Collective Lock Assembly
 Start Date: 18/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3372	Rev B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3								

4 ⁸ FF 12-02-15

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

(xl)

120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5								

4 ⁸ FF 12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

October-18-11 3:30:05 PM

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Start Date: 18/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					4	FF	12-02-16	
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads								
	Qty Part NumberDescription Batch								
	A/R N/A Locktite 262 M120369								
	Identify as D3372-053								
	2-Assemble D3372-051 as per Dwg								
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Tack weld lock shaft as per Dwg D3372								
	A/R SS Rod Batch M114508								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	CPL 12.02.22			4A	2		
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							12 02 23 (4)
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>C92</u> Memo	0.00 0.00							12/12/24 SHD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/28

R12-02-27
(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

October-18-11 3:30:09 PM

75199

D3372-041

Required Qty: 4.00

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC		Purchased	No			100	Each	1,554.000	2	8			
5/16WC SS Flat Washer 5/16 FW516S1													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st376		1161							
					117332	1161							
				ST377		393							
					115072	79							
					115174	53							
					116643	261							
AN5-42A		Purchased	No			100	Each	20.0000	1	4			
AN5-42A Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST341		20							
					108442	20							
AN960-416	NAS1149F0463P	Purchased	No			100	Each	0.0000	2	8			
AN960-416 Washer													
D2728-7		Manufactured	No			100	Each	0.0000	0	0			
D2728-7 Dart Logo label													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-18-11 3:30:09 PM

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Work Order ID: 75199

75199

Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3372-1 Manufactured No

100

Each

2.0000

1

4

D3372-1

Main Body

**

(4)

FF

12-02-15

Location

Loc Qty

Loc Code

GA

2

70038

5202 (4)

2

100

Each

3.0000

1

4

D3372-5

Manufactured No

D3372-5

Cam Lock Shaft

**

(4)

FF

12-02-15

Location

Loc Qty

Loc Code

ST048

3

70035

76485 (4)

3

100

Each

3.0000

1

4

D3372-7

Manufactured No

D3372-7

Slider Body

**

(4)

FF

12-02-15

Location

Loc Qty

Loc Code

ST485

3

69633

1

70036

75203 (4)

2

100

Each

25.0000

1

4

D3373-1

Manufactured No

D3373-1

Cam Lock

**

(4)

FF

12-02-15

Location

Loc Qty

Loc Code

ST049

25

58463

5

74862

75666

20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 75199

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

75199

D3372-041

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3384-043

Manufactured No

100

Each

8.0000

1

4

D3384-043

Cyclic Sock Assembly

80273
77180

(1)
(3)

**

3

FF 12-02-15

Location

Loc Qty

Loc Code

ST480

4

74729

4

ST486

4

70037

4

HX-81

Purchased

No

100

Each

18.0000

1

4

HX-81

1/4"-20 SHCS 3/8" long

**

FF 12-02-15

Location

Loc Qty

Loc Code

ST390

18

114383

18

1120773

(1)
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

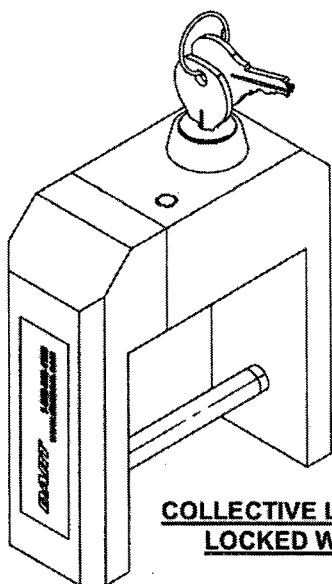
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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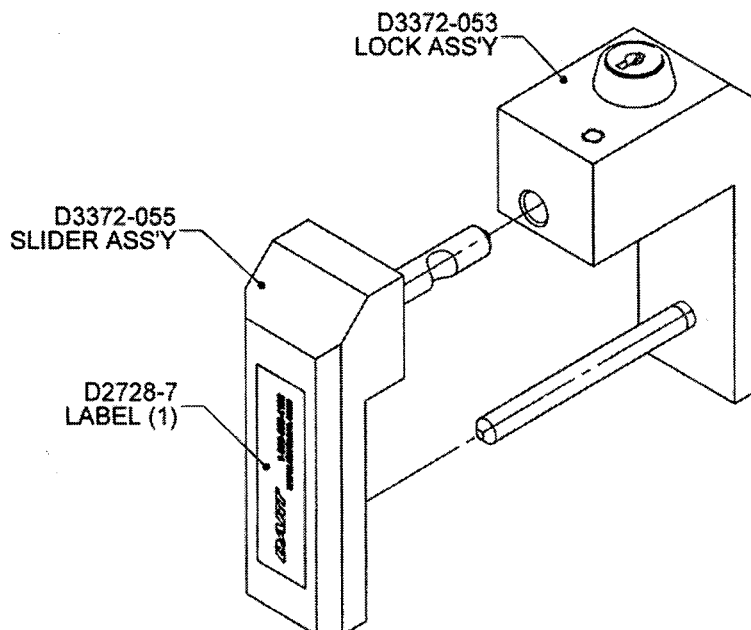
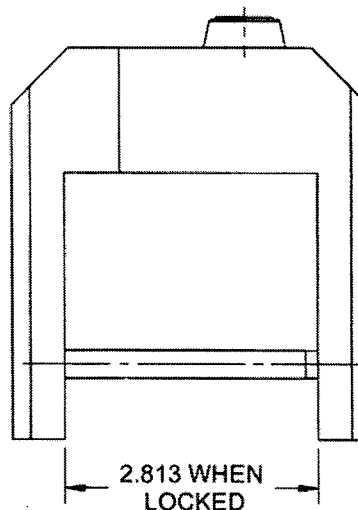
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DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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05/04/28

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75199

H/11-10-18

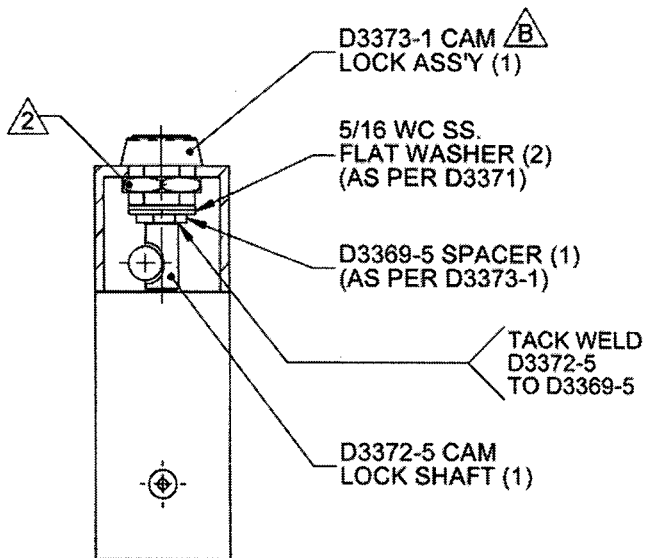
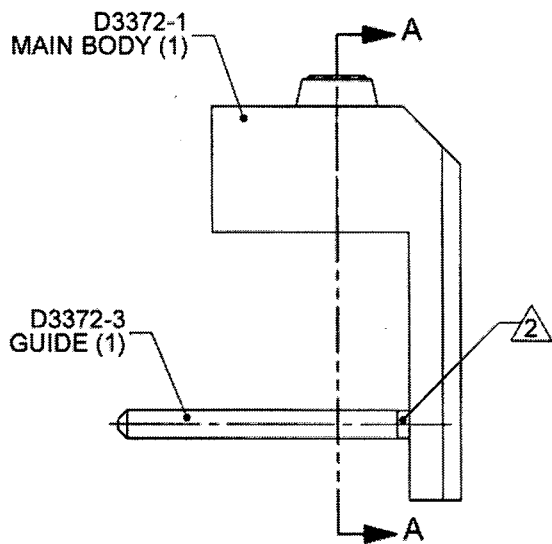
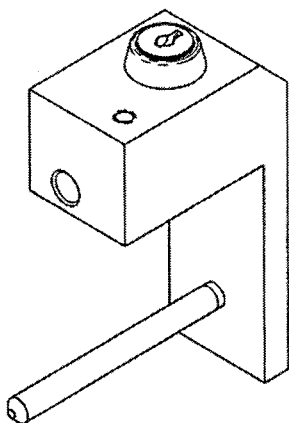
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



SECTION A-A

75199

D3372-053 LOCK ASS'Y

NOTES:

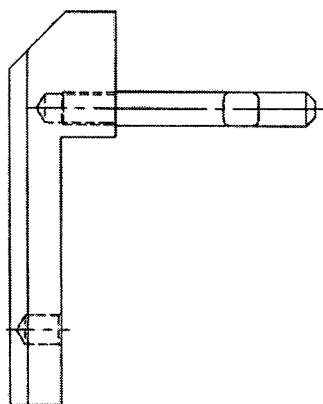
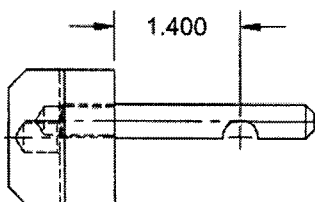
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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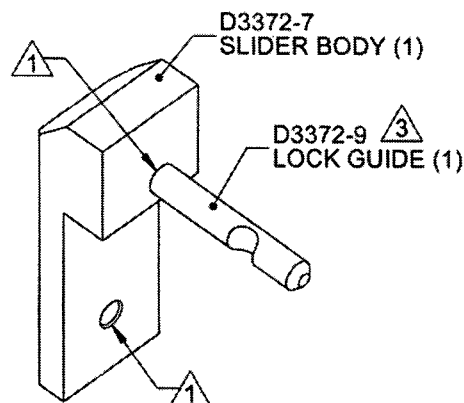
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



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05/04/23



75129

D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

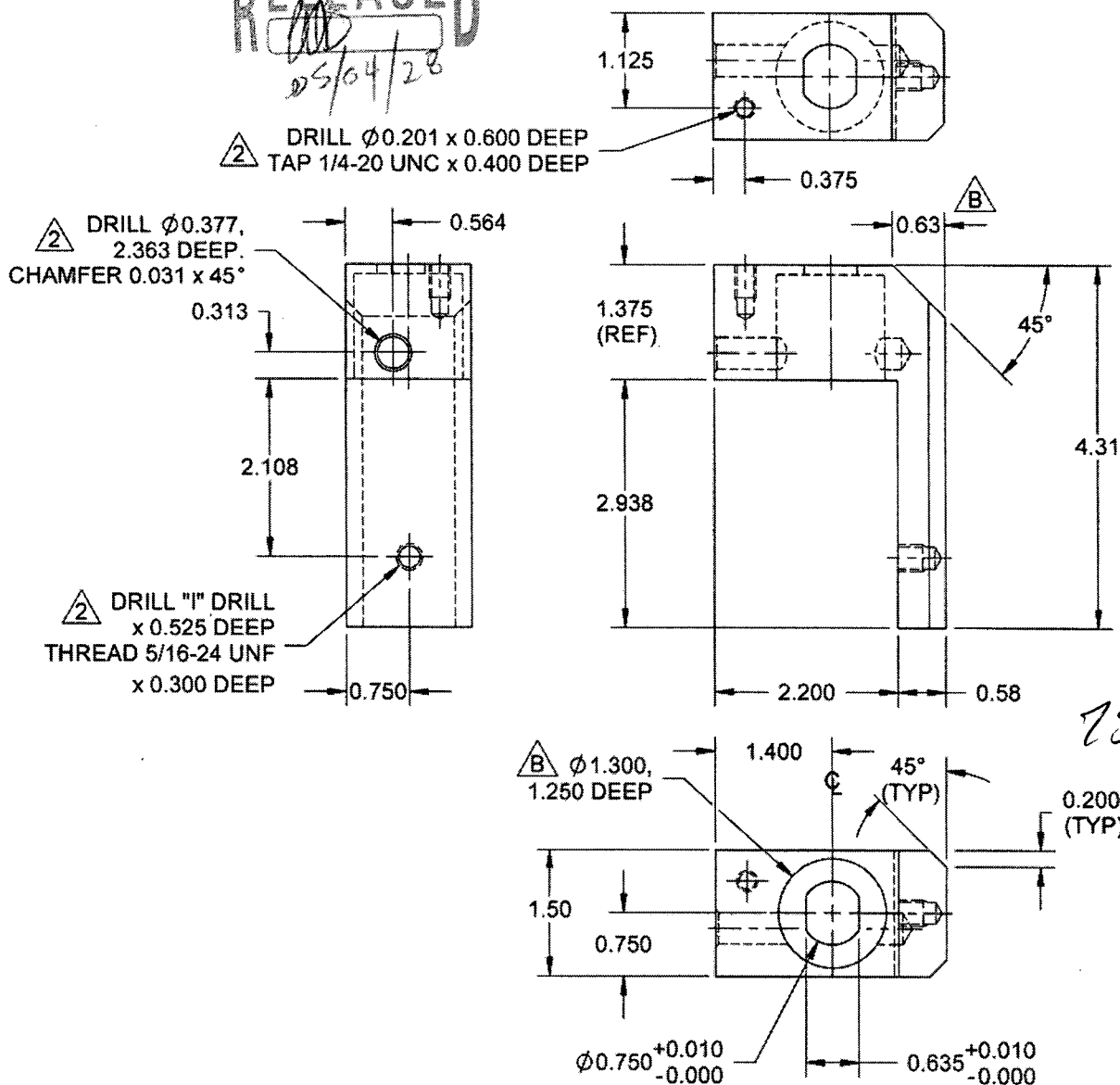
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DATE 05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2	

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05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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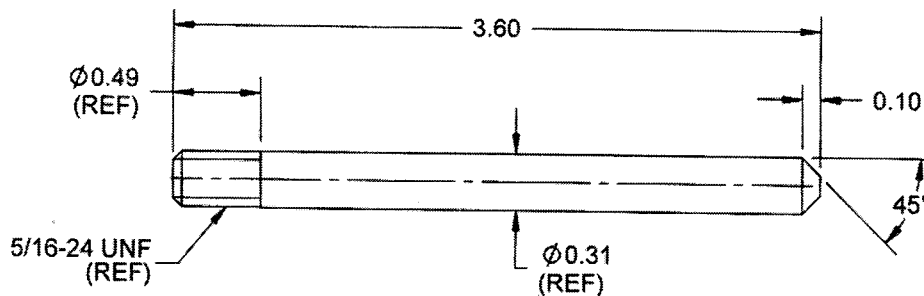
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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05/04/28



75199

D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

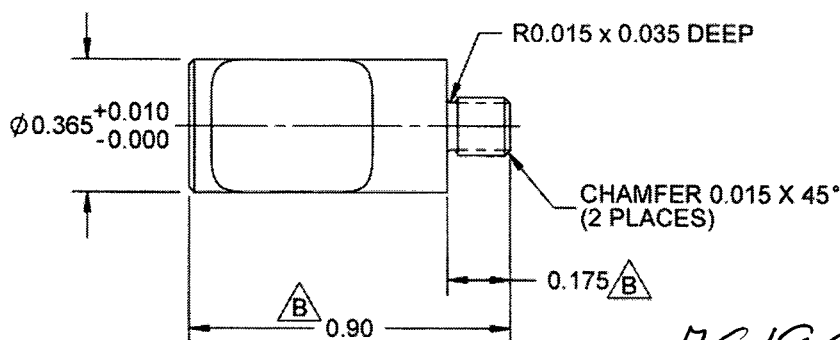
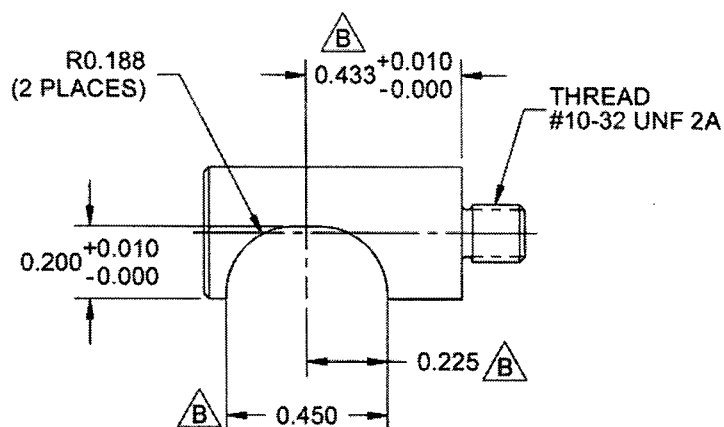
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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75199

D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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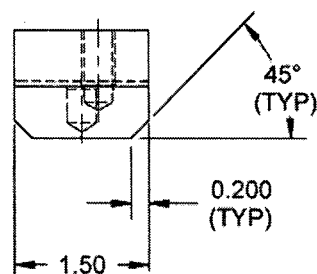
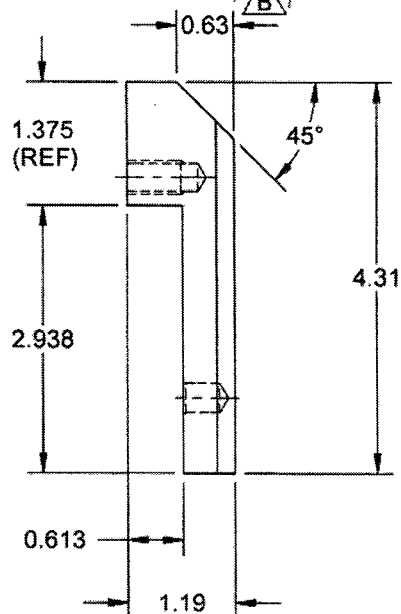
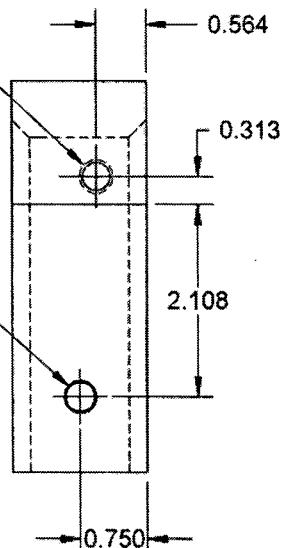
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

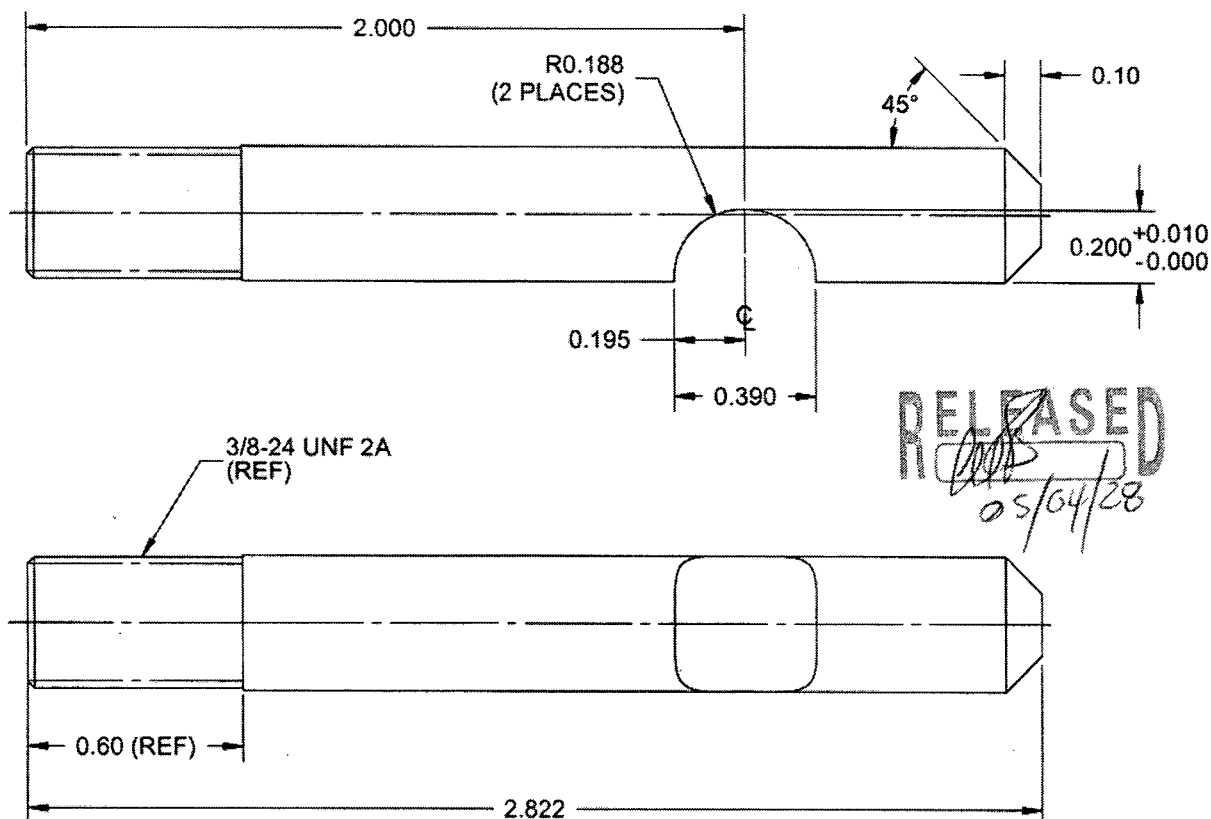
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

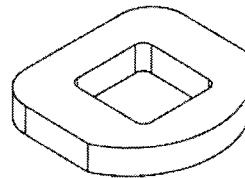
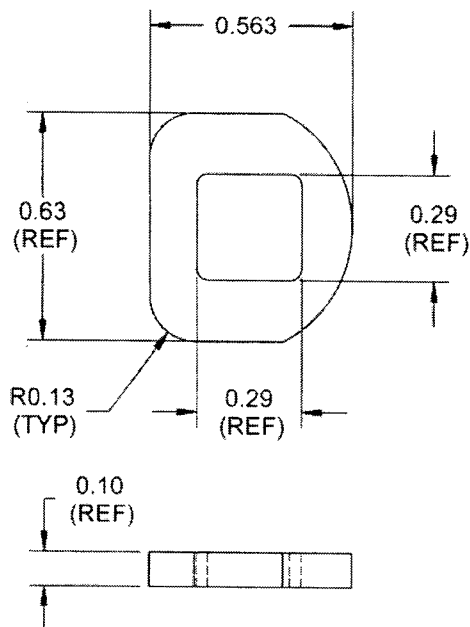
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A
DATE 04.12.16		TITLE BATTERY LOCK	SHEET 4 OF 4 SCALE 2:1

SPECIFICATION CONTROL DRAWING



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05/04/11

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D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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